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(54) **ISOLATION STRUCTURE PROFILE FOR GAP FILLING**

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(57) **ABSTRACT**

(65) **Prior Publication Data**

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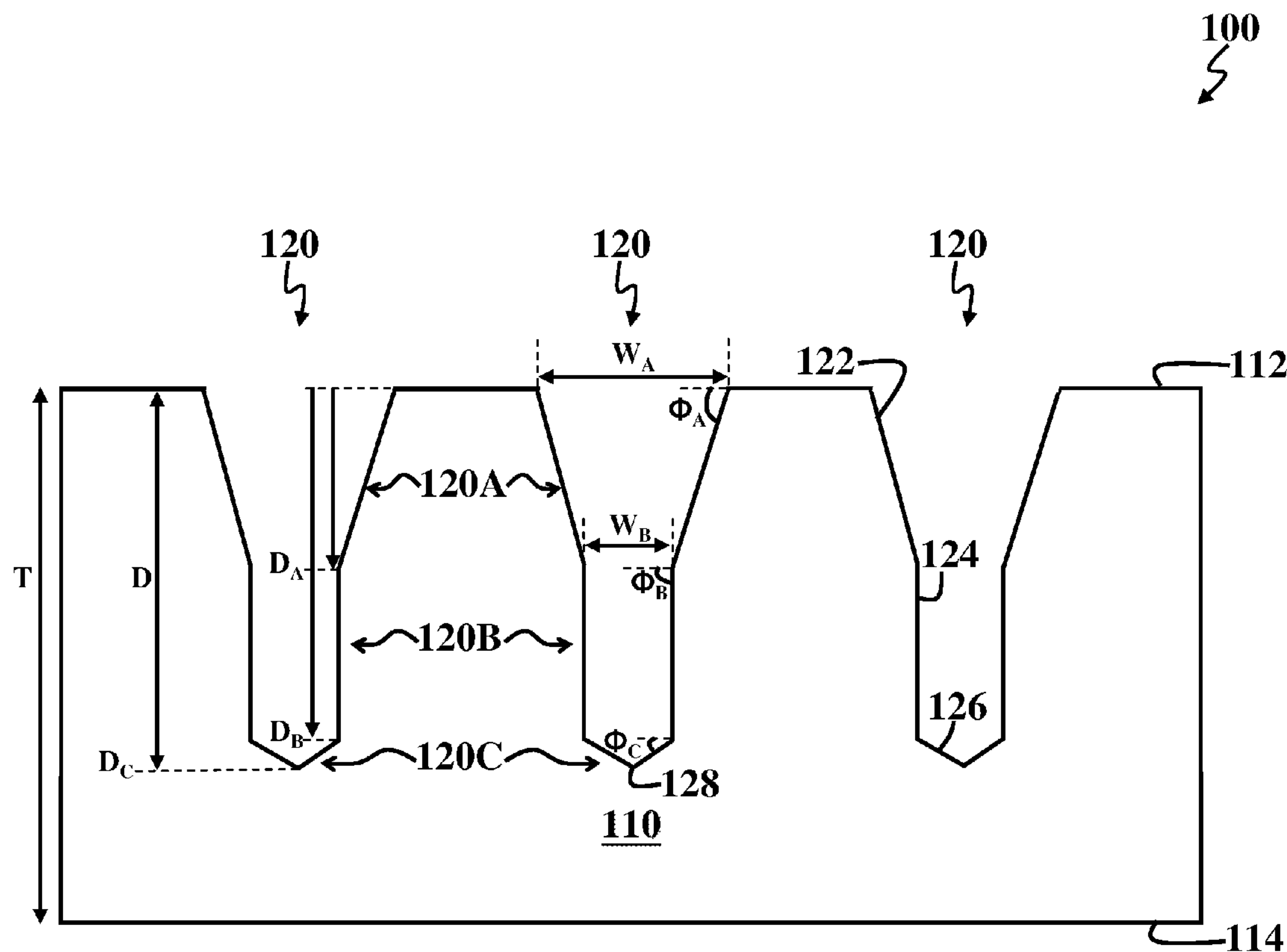
An trench isolation structure and method for manufacturing the trench isolation structure are disclosed. An exemplary trench isolation structure includes a first portion and a second portion. The first portion extends from a surface of a semiconductor substrate to a first depth in the semiconductor substrate, and has a width that tapers from a first width at the surface of the semiconductor substrate to a second width at the first depth, the first width being greater than the second width. The second portion extends from the first depth to a second depth in the semiconductor substrate, and has substantially the second width from the first depth to the second depth.

(51) **Int. Cl.**
H01L 21/70 (2006.01)

(52) **U.S. Cl.**
USPC **257/506; 257/524**

(58) **Field of Classification Search**
USPC **257/524, 506**
See application file for complete search history.

20 Claims, 6 Drawing Sheets



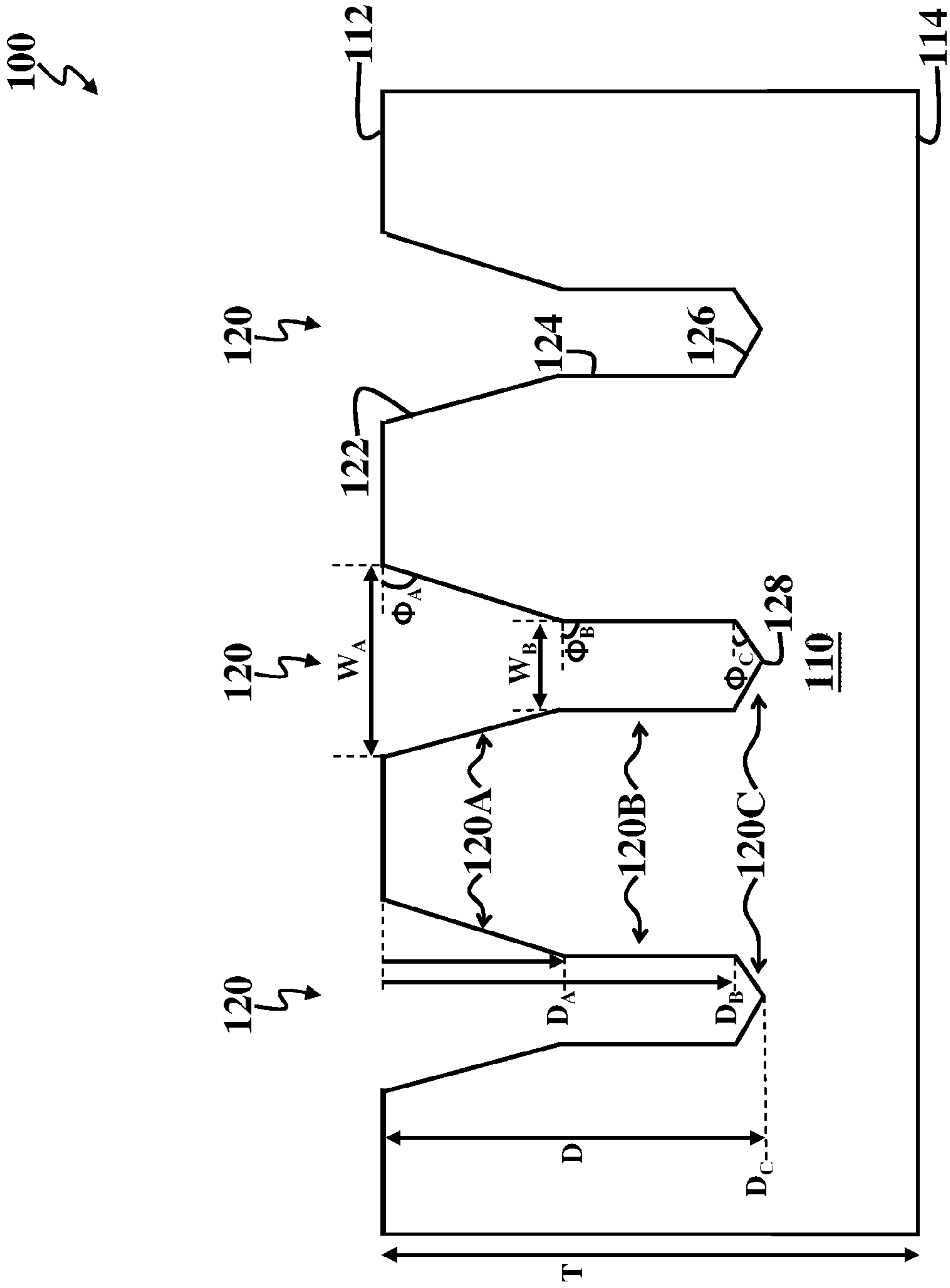


FIG. 1

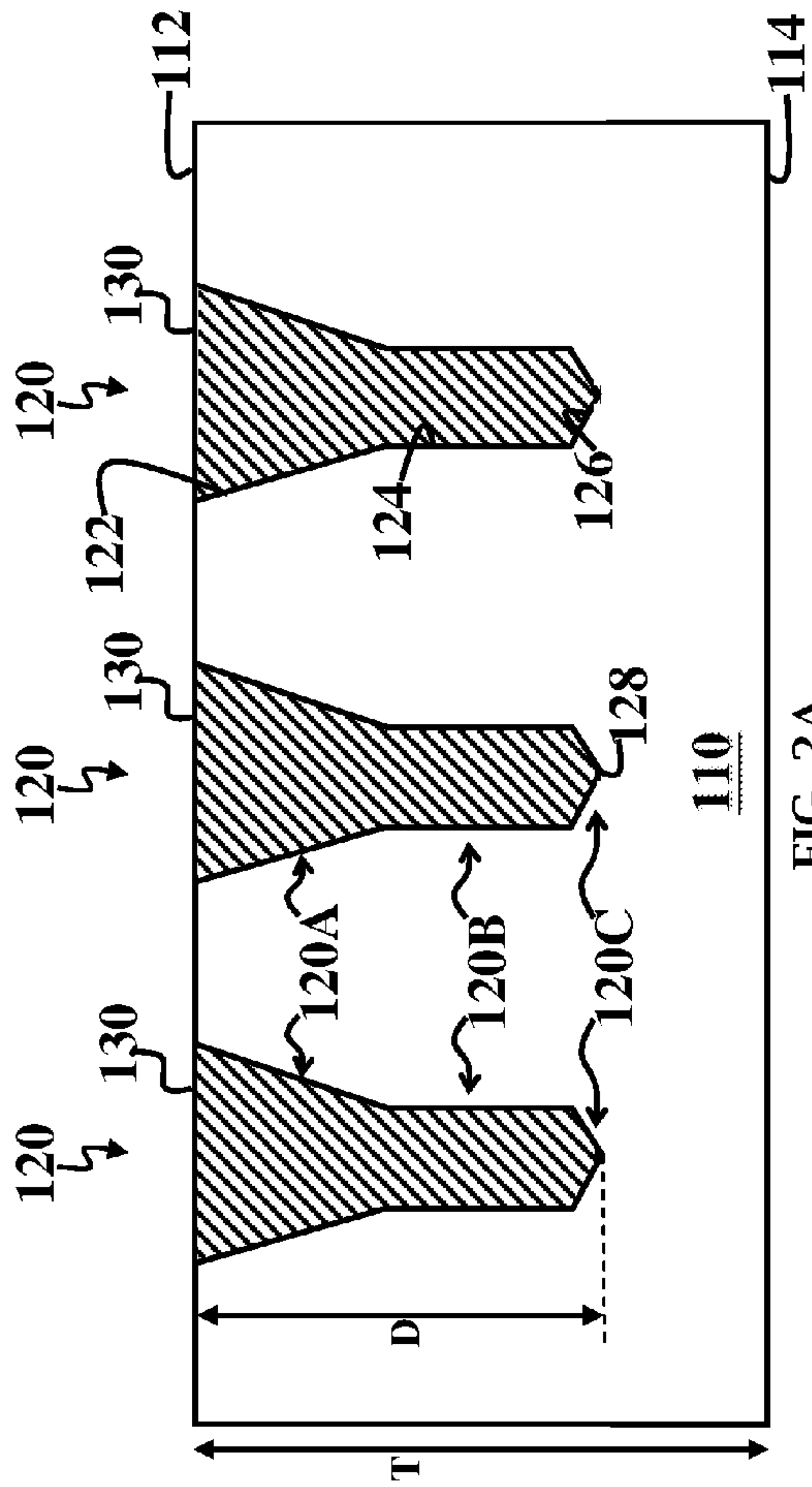


FIG. 2A

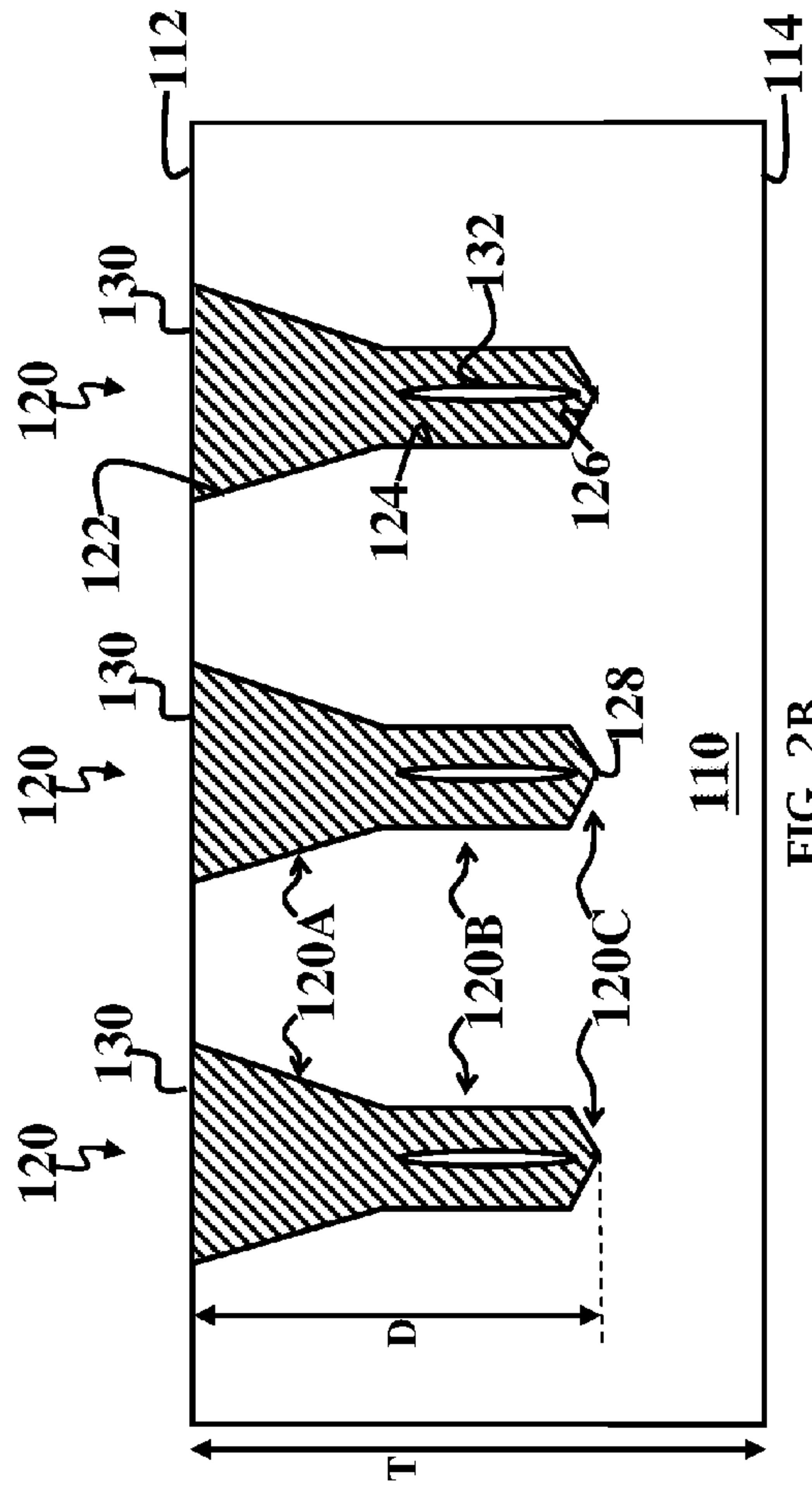


FIG. 2B

200 ↘

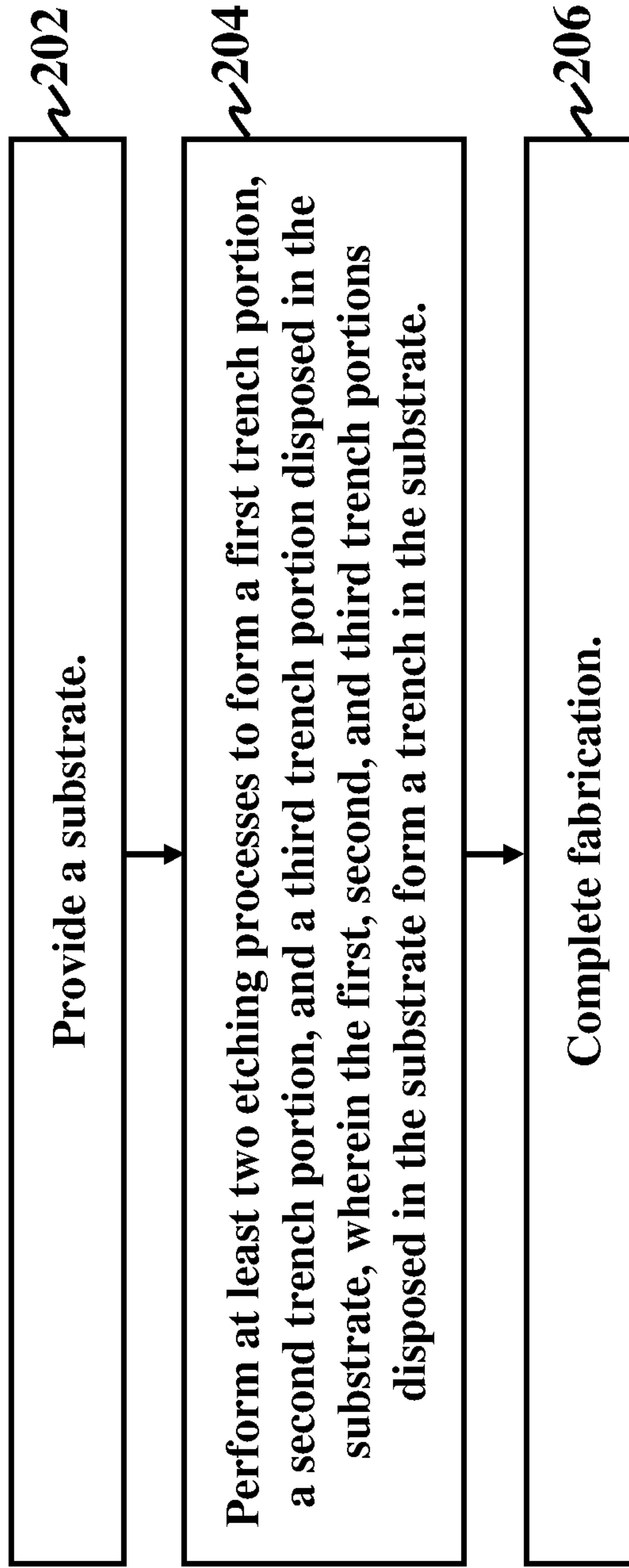


FIG. 3

300 ↘

317 ↘

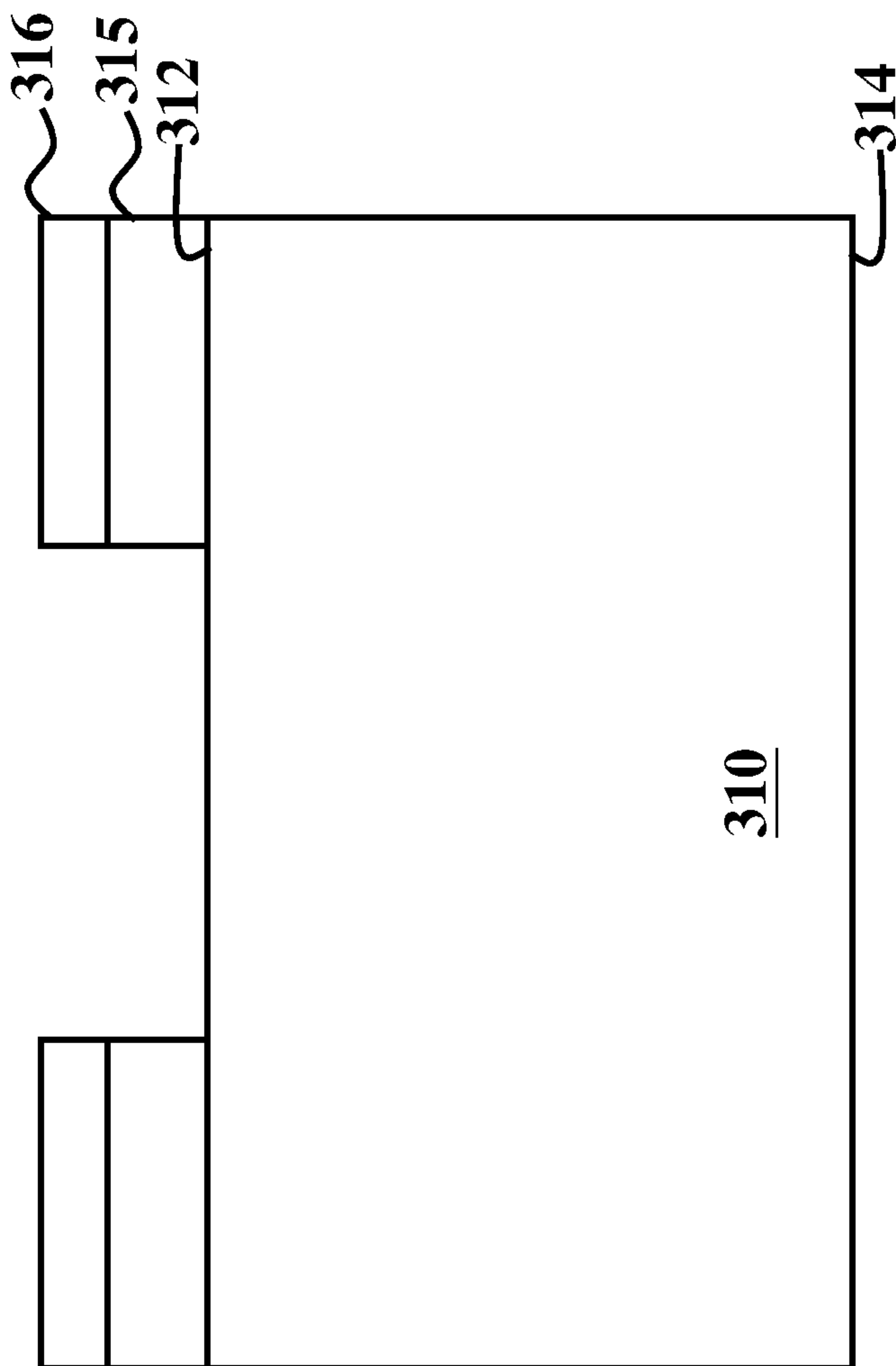


FIG. 4

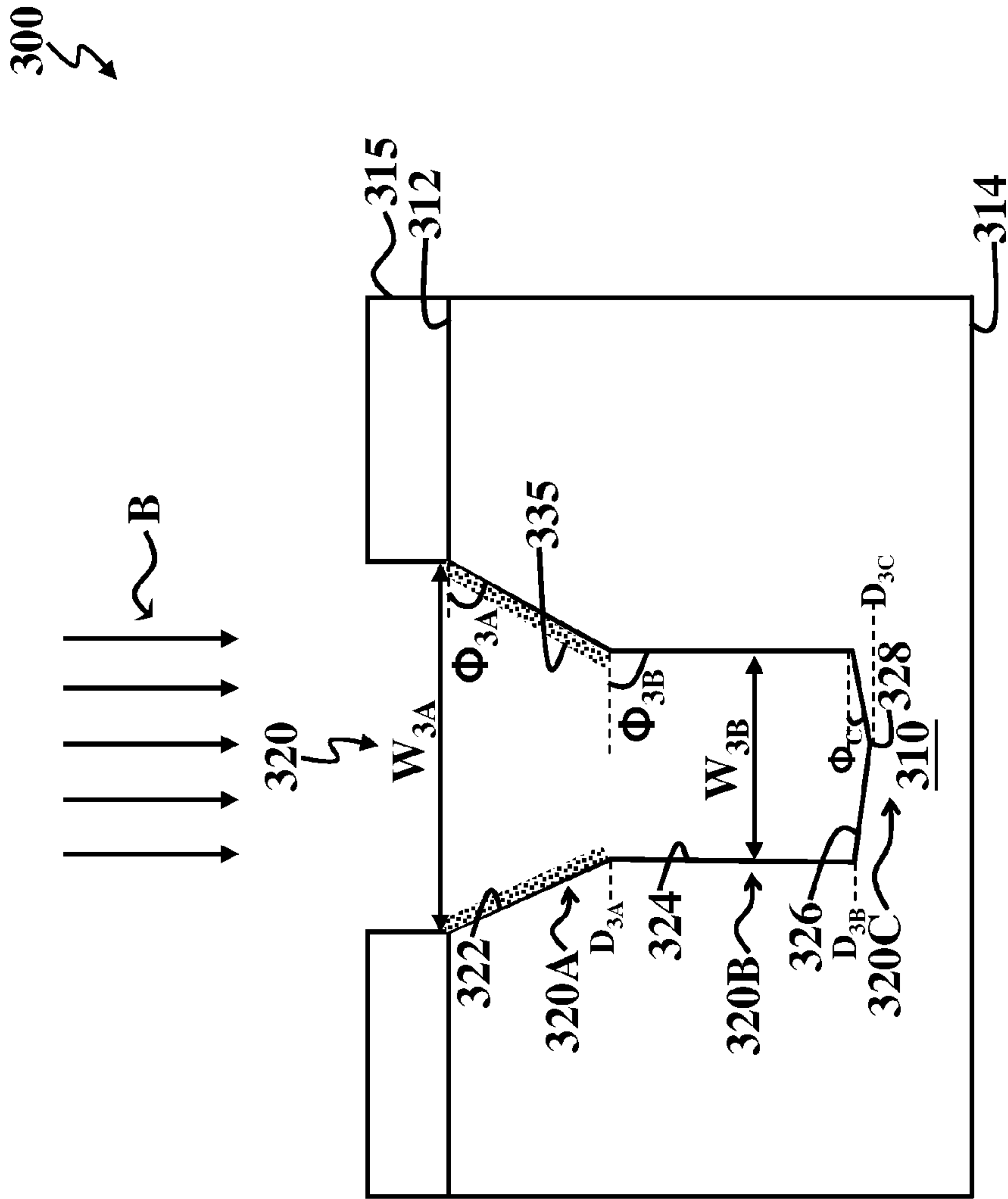


FIG. 6

ISOLATION STRUCTURE PROFILE FOR GAP FILLING

BACKGROUND

The semiconductor integrated circuit (IC) industry has experienced rapid growth. In the course of IC evolution, functional density (i.e., the number of interconnected devices per chip area) has generally increased while geometry size (i.e., the smallest component (or line) that can be created using a fabrication process) has decreased. This scaling down process generally provides benefits by increasing production efficiency and lowering associated costs. Such scaling down has also increased the complexity of processing and manufacturing ICs and, for these advances to be realized, similar developments in IC manufacturing are needed. For example, because a trench isolation structure's aspect ratio increases as device technology nodes scale down, filling the trench isolation structure, such as a shallow trench isolation (STI) structure, has become complex and costly. Conventional trench isolation structure profiles and processes for filling the trench isolation structures implement complex and costly combinations of etching, deposition, annealing, and curing processes to achieve adequate filling. Accordingly, although existing trench isolation structure profiles and methods for filling these trench isolation structures have been generally adequate for their intended purposes, they have not been entirely satisfactory in all respects.

BRIEF DESCRIPTION OF THE DRAWINGS

The present disclosure is best understood from the following detailed description when read with the accompanying figures. It is emphasized that, in accordance with the standard practice in the industry, various features are not drawn to scale and are used for illustration purposes only. In fact, the dimensions of the various features may be arbitrarily increased or reduced for clarity of discussion.

FIG. 1 is a diagrammatic cross-sectional view of an embodiment of a device that includes a trench isolation structure according to various aspects of the present disclosure.

FIGS. 2A and 2B are diagrammatic cross-sectional views of the device of FIG. 1 according to various aspects of the present disclosure.

FIG. 3 is a flow chart of a method for fabricating a trench isolation structure according to various aspects of the present disclosure.

FIGS. 4-6 are various diagrammatic cross-sectional views of an embodiment of a device that includes a trench isolation structure during various fabrication stages according to the method of FIG. 3.

DETAILED DESCRIPTION

The following disclosure provides many different embodiments, or examples, for implementing different features of the invention. Specific examples of components and arrangements are described below to simplify the present disclosure. These are, of course, merely examples and are not intended to be limiting. For example, the formation of a first feature over or on a second feature in the description that follows may include embodiments in which the first and second features are formed in direct contact, and may also include embodiments in which additional features may be formed between the first and second features, such that the first and second features may not be in direct contact. In addition, the present disclosure may repeat reference numerals and/or letters in the

various examples. This repetition is for the purpose of simplicity and clarity and does not in itself dictate a relationship between the various embodiments and/or configurations discussed.

Further, spatially relative terms, such as "beneath," "below," "lower," "above," "upper" and the like, may be used herein for ease of description to describe one element or feature's relationship to another element(s) or feature(s) as illustrated in the figures. The spatially relative terms are intended to encompass different orientations of the device in use or operation in addition to the orientation depicted in the figures. For example, if the device in the figures is turned over, elements described as being "below" or "beneath" other elements or features would then be oriented "above" the other elements or features. Thus, the exemplary term "below" can encompass both an orientation of above and below. The apparatus may be otherwise oriented (rotated 90 degrees or at other orientations) and the spatially relative descriptors used herein may likewise be interpreted accordingly.

FIG. 1 is a diagrammatic cross-sectional view of an embodiment of a device **100** that includes a trench isolation structure according to various aspects of the present disclosure. FIG. 1 has been simplified for the sake of clarity to better understand the inventive concepts of the present disclosure. Additional features can be added in the trench isolation structure **100**, and some of the features described below can be replaced or eliminated for additional embodiments of the trench isolation structure **100**.

In FIG. 1, the device **100** includes a substrate **110**. The substrate may be doped p-type or n-type. In the depicted embodiment, the substrate **110** is a semiconductor substrate including silicon. Alternatively or additionally, the substrate **110** includes another elementary semiconductor, such as germanium and/or diamond; a compound semiconductor including silicon carbide, gallium arsenic, gallium phosphide, indium phosphide, indium arsenide, and/or indium antimonide; an alloy semiconductor including SiGe, GaAsP, AlInAs, AlGaAs, GaInAs, GaInP, and/or GaInAsP; or combinations thereof. The substrate **110** may be a semiconductor on insulator (SOI). The substrate **110** may include a doped epi layer, a gradient semiconductor layer, and/or a semiconductor layer overlying another semiconductor layer of a different type, such as a silicon layer on a silicon germanium layer. The substrate **110** has a surface **112** and a surface **114** that is opposite the surface **112**. A thickness, T , of the substrate **110** is measured between the surfaces **112** and **114**.

The device **100** includes a trench isolation structure having trenches **120** disposed in the substrate **110**. In the depicted embodiment, the trench isolation structure includes three trenches **120** disposed in the substrate **110**. The trench isolation structure may include less trenches, for example only one, or more trenches, depending on design requirements of the device **100**. For ease of discussion, the following will limit discussion to a single trench **120**. In the depicted embodiment, the trench **120** extends from the substrate surface **112** to a depth, D , in the substrate **110**. D is less than the thickness, T , of the substrate **110**. In an example, the trench **120** has a depth, D , from about 1,000 Å to about 3,000 Å. As discussed further below, the trench **120** has a profile that enhances filling of the trench **120** with a material, such as a dielectric material. More specifically, the trench **120** has a profile that includes a first portion **120A**, a second portion **120B**, and a third portion **120C**.

The first portion **120A** extends from the substrate surface **112** to a depth, D_A , in the substrate **110**. In the depicted embodiment, the depth, D_A , is from about 100 Å to about 2,500 Å. A width of the first portion **120A** tapers from the

3

substrate surface **112** to the depth, D_A . For example, the first portion **120A** has a width, W_A , at the substrate surface **112**; a width, W_B , at the depth, D_A ; and a width that ranges between W_A and W_B between the substrate surface **112** and the depth, D_A . In an example, W_A is from about 15 nm to about 45 nm, and W_B is about 5 nm to about 25 nm. The first portion **120A** includes a sidewall **122** that extends at an angle, Φ_A , from the substrate surface **112** to the depth, D_A . In the depicted embodiment, Φ_A between the substrate surface **112** and the sidewall **122** is less than about 85° . In another example, Φ_A between the substrate surface **112** and the sidewall **122** is less than or equal to about 83° .

The second portion **120B** is disposed below the first portion **120A**. The second portion **120B** extends from the depth, D_A , in the substrate **110** to a depth, D_B , in the substrate **110**. In the depicted embodiment, the depth, D_B , is from about 1,000 Å to about 3,000 Å. A width of the second portion **120B** is substantially the same from depth, D_A , to depth, D_B . For example, the second portion **120B** has a width of about W_B from depth, D_A , to depth, D_B . In an example, as noted above, W_B is about 5 nm to about 25 nm. The second portion **120B** includes a sidewall **124** that extends from the sidewall **122** of the first portion **120A** to the depth, D_B . The sidewall **124** is substantially perpendicular to the substrate surface **112**. For example, an angle, Φ_B , between the substrate surface **112** and the sidewall **124** is less than about 120° . In the depicted embodiment, the angle, Φ_B , between the substrate surface **112** and the sidewall **124** is about 90° .

The third portion **120C** is disposed below the second portion **120B**. The third portion **120C** extends from the depth, D_B , in the substrate **110** to a depth, D_C , in the substrate **110**. In the depicted embodiment, the depth, D_C , is equal to the depth, D , of the trench **120**, and thus, the depth, D_C , is from about 1,000 Å to about 3,500 Å. A width of the third portion **120C** tapers from the depth, D_B , to the depth, D_C . For example, the third portion **120C** has the width, W_B , at the depth, D_B ; a width that is about 0 at the depth, D_C ; and a width that ranges between W_B and 0 between the depth, D_B , and the depth, D_C . In an example, as noted above, W_B is about 5 nm to about 25 nm. The third portion **120C** includes a sidewall **126** that extends from the sidewall **124** to the depth, D_C . In the depicted embodiment, since the width of the third portion **120C** tapers to about 0, the sidewall **128** tapers to a point **128**. The point **128** may be rounded point or other suitable shaped point. Further, in the depicted embodiment, an angle, Φ_C , between the substrate surface **112** and the sidewall **128** is less than or equal to about 45° .

Referring to FIGS. 2A and 2B, the trenches **120** may be filled with an insulating material **130**. The insulating material **130** includes a dielectric material, such as silicon oxide, silicon nitride, silicon oxynitride, other suitable materials, or combinations thereof. In the depicted embodiment, the insulating material **130** includes a high density plasma (HDP) oxide, a high aspect ratio process (HARP) oxide, a flowable chemical vapor deposition (CVD) oxide, or combinations thereof. The insulating material **130** that fills the trenches **120** may have a multi-layer structure, such as a thermal oxide liner layer formed on the sidewalls of the trenches **120** and a silicon nitride or silicon oxide layer formed over the thermal oxide liner layer. In the depicted embodiment, the filled trenches **120** isolate various regions of the substrate **110**. For example, the filled trenches **120** may isolate various devices (not shown) of the device **100**. In the depicted embodiment, the filled trenches **120** are shallow trench isolation (STI) structures that define and electrically isolate various regions of the device **100**.

4

The disclosed trench profile facilitates complete filling of the trenches **120** as depicted in FIG. 2A, or the trench profile limits any void **132** formed in the trenches **120** to the second portion **120B** and/or third portion **120C** of the trenches **120**.

5 Confining any void **132** to the bottom portion of the trench, particularly the second portion **120B** and/or third portion **120C**, ensures that the void will not degrade device performance. For example, if the void **132** were to form in the first portion **130A**, the void **132** would likely be filled with a conductive material during subsequent processing, which would degrade device performance. The disclosed trench profile thus facilitates filling of the trench **120** in a way that eliminates the void **132** or confines the void **132** to a portion of the trench **120** that will not interfere with device integrity.

10 As discussed further below, since the disclosed trench profile promotes improved filling of the trench **120** using HDP oxide and HARP oxide deposition processes, the disclosed trench profile reduces manufacturing costs by requiring fewer and less costly processing steps than conventional trench profiles.

15 FIG. 3 is a flow chart of an embodiment of a method **200** for fabricating a trench isolation structure according to various aspects of the present disclosure. The method **200** begins at block **202** where a substrate is provided. At block **204**, at least two etching processes are performed to form a first trench portion, a second trench portion, and a third trench portion disposed in the substrate. The first, second, and third trench portions disposed in the substrate form a trench in the substrate. The method **200** continues with block **206** where fabrication of the trench isolation structure is completed. For example, the trench may be filled with a dielectric material. In an example, the trench is filled with an oxide material formed by a HDP deposition process, a HARP deposition process, a flowable CVD process, other suitable deposition process, or combinations thereof. Additional steps can be provided before, during, and after the method **200**, and some of the steps described can be replaced or eliminated for additional embodiments of the method. The discussion that follows illustrates various embodiments of the trench isolation structure that can be fabricated according to the method **200** of FIG. 3.

20 FIGS. 4-6 are various diagrammatic cross-sectional views of an embodiment of an integrated circuit device **300** during various fabrication stages according to the method **200** of FIG. 3. In the depicted embodiment, the integrated circuit device **300** includes a trench isolation structure. The integrated circuit device **300** may include an integrated circuit (IC) chip, system on chip (SoC), or portion thereof, that includes various passive and active microelectronic components, such as resistors, capacitors, inductors, diodes, metal-oxide-semiconductor field effect transistors (MOSFET), complementary MOS (CMOS) transistors, bipolar junction transistors (BJT), laterally diffused MOS (LDMOS) transistors, high power MOS transistors, fin-like field effect transistors (FinFET), other suitable components, or combinations thereof. The trench isolation structure may isolate the various devices of the integrated circuit device **300**. FIGS. 4-6 have been simplified for the sake of clarity to better understand the inventive concepts of the present disclosure. Additional features can be added in the integrated circuit device **300**, and some of the features described below can be replaced or eliminated for additional embodiments of the integrated circuit device **300**.

25 In FIG. 4, a substrate **310** is provided. In the depicted embodiment, the substrate **310** is a semiconductor substrate including silicon. The substrate may be doped p-type or n-type. Alternatively or additionally, the substrate **310** includes another elementary semiconductor, such as germa-

5

nium and/or diamond; a compound semiconductor including silicon carbide, gallium arsenic, gallium phosphide, indium phosphide, indium arsenide, and/or indium antimonide; an alloy semiconductor including SiGe, GaAsP, AlInAs, AlGaAs, GaInAs, GaInP, and/or GaInAsP; or combinations thereof. The substrate **310** may be a semiconductor on insulator (SOI). The substrate **310** may include a doped epi layer, a gradient semiconductor layer, and/or a semiconductor layer overlying another semiconductor layer of a different type, such as a silicon layer on a silicon germanium layer.

In the depicted embodiment, the substrate **310** has a surface **312** and a surface **314** that is opposite the surface **312**. A thickness of the substrate **310** is measured between the surfaces **312** and **314**. The substrate may be a p-type or an n-type substrate depending on design requirements of the integrated circuit device **300**. P-type dopants that the substrate **310** are doped with include boron, gallium, indium, other suitable p-type dopants, or combinations thereof. N-type dopants that the substrate **310** can be doped with include phosphorus, arsenic, other suitable n-type dopants, or combinations thereof. The substrate **310** may include various p-type doped regions and/or n-type doped regions. Doping may be implemented using a process such as ion implantation or diffusion in various steps and techniques.

A patterning layer **315** is disposed over the substrate surface **312**, and a patterning layer **316** is disposed over the patterning layer **316**. In the depicted embodiment, patterning layers **315** and **316** include a dielectric material, such as silicon oxide, silicon nitride, silicon oxynitride, other suitable dielectric material, or combinations thereof. For example, the patterning layer **315** is a silicon nitride layer, and the patterning layer **316** is an oxide layer. Alternatively, the patterning layer **315** and/or patterning layer **316** may be a resist, such as a photoresist. The patterning layers **315** and **316** include an opening **317** that exposes a portion of the substrate surface **312**. The opening **317** may be formed by a lithography and etching process. The lithography process may include photoresist coating (e.g., spin-on coating), soft baking, mask aligning, exposure, post-exposure baking, developing the photoresist, rinsing, drying (e.g., hard baking), other suitable processes, or combinations thereof. Alternatively, the lithography exposing process may include maskless photolithography, electron-beam writing, or ion-beam writing. The etching processes include dry etching, wet etching, other etching methods, or combinations thereof. In an example, forming the opening **317** may include forming the patterning layers **315** and **316** over the substrate surface **312**, forming a photoresist layer over the patterning layer **316**, exposing and developing the photoresist layer to have an opening therein that exposes the patterning layer **316**, and etching the exposed patterning layer **316** and underlying patterning layer **315** until the portion of the substrate surface **312** is exposed.

In FIG. 5, an etching process A removes exposed portions of the substrate **310** to form trench **318** in the substrate **310**. The etching process A is controlled to achieve a desired profile of the trench **318**. More specifically, the etching process A uses a polymer rich gas that is tuned to achieve a first trench portion (such as first trench portion **120A** described with reference to FIGS. 1 and 2A-2B) having a tapered profile, such as that illustrated in FIG. 5. The trench **318** has a sidewall **322** that extends from the substrate surface **312** into the substrate **310**. An angle, $\Phi_{3,A}$, between the substrate surface **312** and the sidewall **322** is less than about 85° . In the depicted embodiment, the etching process A is a dry etching process. The dry etching process has etching parameters that can be tuned, such as etchants used, etching pressure, source power, radio-frequency (RF) bias voltage, RF bias power,

6

etchant flow rate, and other suitable parameters. For example, an etching pressure of about 1 mT (milli-Torr) to about 50 mT may be used, a source power of about 500 W (Watts) to about 2,000 W, and an etchant that includes a carbon fluoride containing gas (such as CH_2F_2 , CH_3F , C_2F_6 , C_3F_8 , C_4F_6 , C_4F_8 , or combinations thereof), a chlorine containing gas (such as Cl_2), an oxygen containing gas (such as O_2), a hydrogen containing gas (such as HBr, CH_4 , or combinations thereof), other suitable gases, or combinations thereof may be used. In an example, the etching process A uses an etching pressure of about 1 mT to about 50 mT, a source power of about 500 W to about 2,000 W, an RF bias voltage of about 50 V (Volts) to about 300 V, a CH_2F_2 gas flow of about 15 sccm (standard cubic centimeters per minute) to about 45 sccm, a Cl_2 gas flow of about 40 sccm to about 120 sccm, an O_2 gas flow of about 5 sccm to about 20 sccm, and an HBr gas flow of about 200 sccm to about 500 sccm. The etching profile of the trench **318** has a suitable depth. During the etching process, a polymer layer **335** forms on sidewalls **322** of the trench **318**. The polymer layer **335** will prevent subsequent etching processes from affecting the tapered profile of the trench **318**, thereby ensuring that the angle, $\Phi_{3,A}$, between the substrate surface **312** and the sidewall remains less than about 85° .

After the etching process A, portions of the substrate **310** remain exposed in the trench **318**. In FIG. 6, an etching process B removes exposed portions of the substrate **310** to form trench **320** in the substrate **310**. The etching process B uses a leaner chemistry than etching process A that is controlled to achieve a desired trench profile for the trench **320**. More specifically, the etching process B is tuned to achieve a first trench portion **320A**, a second trench portion **320B**, and a third trench portion **320C**. During the etching process B, the leaner chemistry can form a slight passivation layer that facilitates forming the second trench portion **320B** with a vertical profile. Because etching process B uses a leaner chemistry, the etching process B (particularly gases used in the etching process) will generate less of a passivation layer on the trench sidewalls when compared to etching process A. In the depicted embodiment, the etching process B is a dry etching process. The dry etching process has etching parameters that can be tuned, such as etchants used, etching pressure, source power, radio-frequency (RF) bias voltage, RF bias power, etchant flow rate, and other suitable parameters. Particularly, the etching process may be tuned to achieve a vertical profile of second trench portion **320B** of the trench **320**. For example, an etching pressure of about 1 mT (milli-Torr) to about 50 mT may be used, a source power of about 200 W (Watts) to about 1,000 W, and an etchant that includes a fluorine containing gas (such as SF_6 , CH_2F_2 , CF_4 , CH_3F , C_2F_6 , C_3F_8 , C_4F_6 , C_4F_8 , NF_3 , or combinations thereof), a chlorine containing gas (such as Cl_2), a nitrogen containing gas (such as N_2), an oxygen containing gas (such as O_2), a hydrogen containing gas (such as HBr, CH_4 , or combinations thereof), a helium containing gas (such as He), other suitable gasses, or combinations thereof may be used. In an example, the etching process B uses an etching pressure of about 1 mT to about 50 mT, a source power of about 200 W to about 1,000 W, an RF bias voltage of about 20 V (Volts) to about 200 V, an SF_6 gas flow of about 20 sccm to about 100 sccm, a CH_2F_2 gas flow of about 30 sccm to about 100 sccm, a N_2 gas flow of about 30 sccm to about 150 sccm, an He gas flow of about 50 sccm to about 300 sccm.

In FIGS. 5 and 6, the etching processes A and B achieve a trench profile that enhances subsequent filling of the trench **320**. The first portion **320A**, second portion **320B**, and third portion **320C** form a funnel-shaped trench profile that has a vertical portion positioned between two tapered portions. The

first portion **320A** extends from the substrate surface **312** to a depth, D_{3A} , in the substrate **310**. In the depicted embodiment, the depth, D_{3A} , is from about 100 Å to about 2,500 Å. A width of the first portion **320A** tapers from the substrate surface **312** to the depth, D_{3A} . For example, the first portion **320A** has a width, W_{3A} , at the substrate surface **312**; a width, W_{3B} , at the depth, D_{3A} ; and a width that ranges between W_{3A} and W_{3B} between the substrate surface **312** and the depth, D_{3A} . In an example, W_{3A} is from about 15 nm to about 45 nm, and W_{3B} is about 5 nm to about 25 nm. The first portion **320A** includes the sidewall **322** that extends at the angle, Φ_{3A} , from the substrate surface **312** to the depth, D_{3A} . As noted above, in the depicted embodiment, Φ_{3A} between the substrate surface **312** and the sidewall **322** is less than about 85°. In another example, Φ_{3A} between the substrate surface **312** and the sidewall **322** is less than or equal to about 83°.

The second portion **320B** is disposed below the first portion **320A**. The second portion **320B** extends from the depth, D_{3A} , in the substrate **310** to a depth, D_{3B} , in the substrate **310**. In the depicted embodiment, the depth, D_{3B} , is from about 100 Å to about 3,000 Å. A width of the second portion **320B** is substantially the same from depth, D_{3A} , to depth, D_{3B} . For example, the second portion **320B** has a width of about W_{3B} from depth, D_{3A} , to depth, D_{3B} . In an example, as noted above, W_{3B} is about 5 nm to about 25 nm. The second portion **320B** includes a sidewall **324** that extends from the sidewall **322** of the first portion **320A** to the depth, D_{3B} . The sidewall **324** is substantially perpendicular to the substrate surface **312**. For example, an angle, Φ_{3B} , between the substrate surface **312** and the sidewall **324** is less than about 120°. In the depicted embodiment, the angle, Φ_{3B} , between the substrate surface **312** and the sidewall **324** is about 90°.

The third portion **320C** is disposed below the second portion **320B**. The third portion **320C** extends from the depth, D_{3B} , in the substrate **310** to a depth, D_{3C} , in the substrate **310**. In the depicted embodiment, the depth, D_{3C} , is a depth of the trench **320**. In an example, the depth, D_{3C} , is from about 1,000 Å to about 3,500 Å. A width of the third portion **320C** tapers from the depth, D_{3B} , to the depth, D_{3C} . For example, the third portion **320C** has the width, W_{3B} , at the depth, D_{3B} ; a width that is about 0 at the depth, D_{3C} ; and a width that ranges between W_{3B} and 0 between the depth, D_{3B} , and the depth, D_{3C} . In an example, as noted above, W_{3B} is about 5 nm to about 25 nm. The third portion **320C** includes a sidewall **326** that extends from the sidewall **324** to the depth, D_{3C} . In the depicted embodiment, since the width of the third portion **320C** tapers to about 0, the sidewall **328** tapers to a point **328**. The point **328** may be rounded point or other suitable shaped point. Further, in the depicted embodiment, an angle, Φ_{3C} , between the substrate surface **312** and the sidewall **328** is less than or equal to about 45°.

The disclosed trench profile of the trench **320**, which is achieved by the etching processes A and B, facilitates adequate filling of the trench **320** using conventional insulating materials, such as a dielectric material. For example, the trench **320** may be filled with silicon oxide, silicon nitride, silicon oxynitride, other suitable materials, or combinations thereof. In an example, the insulating material filling the trench **320** includes a HDP oxide, a HARP oxide, a flowable CVD oxide, or combinations thereof. The insulating material that fills the trench **320** may have a multi-layer structure, such as a thermal oxide liner layer formed on the sidewalls of the trenches **320** and a silicon nitride or silicon oxide layer formed over the thermal oxide liner layer. The filled trench **320** isolates various regions of the substrate **310**. In an example, the filled trench **320** may be a shallow trench isola-

tion (STI) structure that defines and electrically isolates various regions of an integrated circuit device.

The disclosed trench profile of the trench **320** facilitates complete filling of the trench, or confines any void formed in the insulating material to the second portion **320B** and/or third portion **320C** of the trench **320**. Confining voids to the bottom portion of the trench, particularly the second portion **320B** and/or third portion **320C**, ensures that the void will not degrade device performance. The disclosed trench profile thus facilitates filling of the trench **320** in a way that eliminates voids or confines voids to a portion of the trench **320** that will not interfere with device integrity. Since the disclosed trench profile promotes improved filling of the trench **320** using HDP oxide and HARP oxide deposition processes, the disclosed trench profile eliminates the need for more complex and costly processes used to fill trenches at smaller technology nodes, such as 20 nm technology nodes and below. Instead, the disclosed trench profile is formed and filled with reduced manufacturing costs. It is understood that different embodiments may have different advantages, and that no particular advantage is necessarily required of any embodiment.

The present disclosure provides for many different embodiments. For example, a trench isolation structure includes a first trench isolation portion, a second trench isolation portion, and third trench isolation portion. The first trench isolation portion has a first sidewall that extends from a surface of a semiconductor substrate to a first depth in the semiconductor substrate, where a first angle between the first sidewall and the surface of the semiconductor substrate is less than or equal to about 85°. The second trench isolation portion has a second sidewall that extends from the first sidewall at the first depth to a second depth in the semiconductor substrate, where a second angle between the second sidewall and the surface of the semiconductor substrate is about 90°. The third trench isolation portion has a third sidewall that extends from the second sidewall at the second depth to a third depth in the semiconductor substrate, where a third angle between the third sidewall and the surface of the semiconductor substrate is less than 90°, for example, less than or equal to about 45°.

The first trench isolation portion may have a width that tapers from a first width at the surface of the semiconductor substrate to a second width at the first depth, the first width being greater than the second width. The second trench isolation portion may have a width that is substantially equal to the second width from the first depth to the second depth. The third trench isolation portion may have a width that tapers from the second width at the second depth to a third width at the third depth, the second width being greater than the third width. A bottom portion of the third isolation portion may be a rounded point. The first, second, and third trench isolation portions may be filled with an insulating material. Any void in the insulating material may be confined within the second trench isolation portion, third trench isolation portion, or both the second and third trench isolation portions.

In another example, a device includes a semiconductor substrate and a trench in the semiconductor substrate. The trench includes a first portion, a second portion, and a third portion. The first portion extends from a surface of a semiconductor substrate to a first depth in the semiconductor substrate, and has a width that tapers from a first width at the surface of the semiconductor substrate to a second width at the first depth, the first width being greater than the second width. The second portion extends from the first depth to a second depth in the semiconductor substrate, and has substantially the second width from the first depth to the second

depth. The third portion extends from the second depth to a third depth in the semiconductor substrate, and has a width that tapers from the second width at the second depth to a third width at the third depth, the second width being greater than the third width.

The first portion may include a tapered sidewall, where an angle between the surface of the semiconductor substrate and the tapered sidewall is less than about 85° . The second portion may include a sidewall, where an angle between the surface of the semiconductor substrate and the sidewall is less than about 120° . The third portion may include a tapered sidewall, where an angle between the surface of the semiconductor substrate and the tapered sidewall is less than 90° , for example, less than or equal to about 45° . The first depth may be from about 100 \AA to about $2,500 \text{ \AA}$, and the third depth may be from about 1000 \AA to about $3,000 \text{ \AA}$. The third width may be about 0, such that a bottom portion of the trench is a point. The device may further include a dielectric material disposed in the trench. The trench may be a shallow trench isolation (STI) structure.

In yet another example, a method includes providing a semiconductor substrate, performing at least two etching processes to form a trench in the semiconductor substrate, and filling the trench with a material. Performing the at least two etching processes includes performing a first etching process to form a first trench portion, and performing a second etching process to form a second trench portion and a third trench portion. The first trench portion extends from a surface of the semiconductor substrate to a first depth in the semiconductor substrate, wherein the first portion has a width that tapers from a first width at the surface of the semiconductor substrate to a second width at the first depth, the first width being greater than the second width. The second trench portion extends from the first depth to a second depth in the semiconductor substrate, wherein the second portion has substantially the second width from the first depth to the second depth. The third portion extends from the second depth to a third depth in the semiconductor substrate, wherein the third portion has a width that tapers from the second width at the second depth to a third width at the third depth, the second width being greater than the third width. Performing the first etching process and the second etching process may include using a carbon fluoride gas. In an example, performing the first etching process includes using an etching recipe that includes a CH_2F_2 gas, a Cl_2 gas, a O_2 gas, and a HBr gas. In an example, performing the second etching process includes using an etching recipe that includes a CH_2F_2 gas, a SF_6 gas, a N_2 gas, and a He gas. Filling the trench with the material may include depositing a high aspect ratio process (HARP) oxide or a high density plasma (HDP) oxide in the trench. In an example, before depositing the HARP oxide or HDP oxide, a flowable chemical vapor deposition (CVD) process is performed to form a flowable CVD oxide in the trench.

The foregoing outlines features of several embodiments so that those skilled in the art may better understand the aspects of the present disclosure. Those skilled in the art should appreciate that they may readily use the present disclosure as a basis for designing or modifying other processes and structures for carrying out the same purposes and/or achieving the same advantages of the embodiments introduced herein. Those skilled in the art should also realize that such equivalent constructions do not depart from the spirit and scope of the present disclosure, and that they may make various changes, substitutions, and alterations herein without departing from the spirit and scope of the present disclosure.

What is claimed is:

1. A device comprising:

a semiconductor substrate; and

a trench in the semiconductor substrate that includes:

5 a first portion extending from a surface of the semiconductor substrate to a first depth in the semiconductor substrate, wherein the first portion has a width that tapers from a first width at the surface of the semiconductor substrate to a second width at the first depth, the first width being greater than the second width,
10 a second portion extending from the first depth to a second depth in the semiconductor substrate, wherein the second portion has substantially the second width from the first depth to the second depth, and
15 a third portion extending from the second depth to a third depth in the semiconductor substrate,
wherein the third portion includes a first substantially linear sidewall and a second substantially linear sidewall,
wherein the first substantially linear sidewall has a first length and the second substantially linear sidewall has a second length, wherein the first and second length extend from the second depth to the third depth,
wherein the first substantially linear sidewall and the second substantially linear sidewalls physically contact at the third depth, and
25 wherein the first length is transverse to a top surface of the semiconductor substrate and the second length is transverse to the top surface of the semiconductor substrate.

2. The device of claim 1 wherein the first portion includes
30 a tapered sidewall, an angle between the surface of the semiconductor substrate and the tapered sidewall being less than about 85° .

3. The device of claim 1 wherein the second portion includes a sidewall, an angle between the surface of the semiconductor substrate and the sidewall being less than about 120° .

4. The device of claim 1 further including a high density plasma oxide material that fills the trench.

5. The device of claim 1 wherein an angle between the surface of the semiconductor substrate and the first substantially linear sidewall of the third portion is greater than 0° and less than or equal to about 45° .

6. The device of claim 1 wherein:

a first angle between a sidewall of the first portion and the surface of the semiconductor substrate is about 83° to about 85° ;

a second angle between a sidewall of the second portion and the surface of the semiconductor substrate is about 90° ; and

50 a third angle between the first substantially linear sidewall of the third portion and the surface of the semiconductor substrate is greater than 0° and less than or equal to about 45° .

7. The device of claim 1 further including a high aspect ratio process oxide material that fills the trench.

8. The device of claim 1 wherein the trench is a shallow trench isolation (STI) structure.

9. A device comprising:

a semiconductor substrate; and

60 a trench isolation structure in the semiconductor substrate, wherein the trench isolation structure has a third depth in the semiconductor substrate and includes:

a first trench isolation portion having a first sidewall that extends from a surface of the semiconductor substrate to a first depth in the semiconductor substrate, a first angle being between the first sidewall and the surface of the semiconductor substrate;

11

a second trench isolation portion having a second sidewall that extends from the first sidewall at the first depth to a second depth in the semiconductor substrate, a second angle being between the second sidewall and the surface of the semiconductor substrate, wherein the first angle is less than the second angle; and

a third trench isolation portion having a third sidewall that extends from the second sidewall at the second depth to the third depth in the semiconductor substrate, wherein an entire length of the third sidewall is disposed at a third angle, the third angle being defined between the third sidewall and the surface of the semiconductor substrate, and wherein the third angle is greater than zero and less than the first angle and the second angle.

10. The device of claim **9** wherein the first trench isolation portion has a width that tapers from a first width at the surface of the semiconductor substrate to a second width at the first depth, the first width being greater than the second width.

11. The device of claim **10** wherein the second trench isolation portion has a width that is substantially equal to the second width from the first depth to the second depth.

12. The device of claim **9** wherein the first, second, and third trench isolation portions are filled with an insulating material.

13. The device of claim **11** wherein the third trench isolation portion has a width that tapers from the second width at the second depth to a point at the third depth.

14. The device of claim **9** wherein the first angle is less than or equal to about 85° , the second angle is about 90° , and the third angle is about 45° .

15. The device of claim **12** wherein the insulating material in the second trench isolation portion includes a void and the insulating material in the first trench isolation portion is free of the void.

16. A device comprising:
a semiconductor substrate; and
a trench in the semiconductor substrate, comprising:
a first trench portion extending from a surface of the semiconductor substrate to a first depth in the semi-

12

conductor substrate, wherein the first trench portion has a width that tapers from a first width at the surface of the semiconductor substrate to a second width at the first depth, the first width being greater than the second width,

a second trench portion, the second trench portion extending from the first depth to a second depth in the semiconductor substrate, wherein the second trench portion has substantially the second width from the first depth to the second depth;

a third trench portion extending from the second depth to a third depth in the semiconductor substrate, wherein the third trench portion has a width that tapers from the second width at the second depth to a third width at the third depth, the second width being greater than the third width, and wherein the third trench portion includes a substantially linear sidewall extending from the second depth to the third depth; and

a material in the trench, wherein the material in the second trench portion includes a void therein and the material in the first trench portion is free of the void.

17. The device of claim **16** wherein the void is further disposed in the material in the third trench portion.

18. The device of claim **16** wherein the material is one of a high aspect ratio process oxide material and a high density plasma oxide material.

19. The device of claim **16** wherein:

a first angle between a sidewall of the first trench portion and the surface of the semiconductor substrate is about 83° to about 85° ;

a second angle between a sidewall of the second trench portion and the surface of the semiconductor substrate is about 90° ; and

a third angle between the substantially linear sidewall of the third trench portion and the surface of the semiconductor substrate is about 45° .

20. The device of claim **16** wherein the width of the third trench portion tapers to a point at the third depth.

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